

Work Order ID 106345

Thursday, August 29, 2013 12:55:27 PM

106345

Page 1

Item ID: PB67-43001-67

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 90° Blade Support Assembly

Start Date: 8/29/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/5/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *B-8-29*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

B67-43001-67

Rev C

150

Weld per dwg A/R Aluminum rod Batch: *B5127* 0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Install nut plates as per dwg

2- Weld assembly as per dwg B67-43001

160

QC9- Inspect visual per QS1004- Fusion Welds 0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O 0.00

170

QC

Memo

0.00

Quality Control

8/30/29
13-09-03

8 13-09-03

DAS
09
9-03

8 13-09-03

DAS
09
9-03

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

200

Identify as per dwg & Stock Location: W114.003 0.00***200***

Packaging

Memo

M122 P110 0.00

Packaging

210

QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

Quality Control

8 8
13/9/03
13/9/03
13-09-03

Picklist Print

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Page 1

Work Order ID: 106345
Parent Item: PB67-43001-67
Parent Item Name: 90° Blade Support Assembly

Start Date: 8/29/2013

Required Date: 9/5/2013

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:cc
IPP Rev:B 08-09-23 remove alodine and QC3 DD verified EC IPP rev B 10.09.30 per rev C
dwg EC verified by:DD

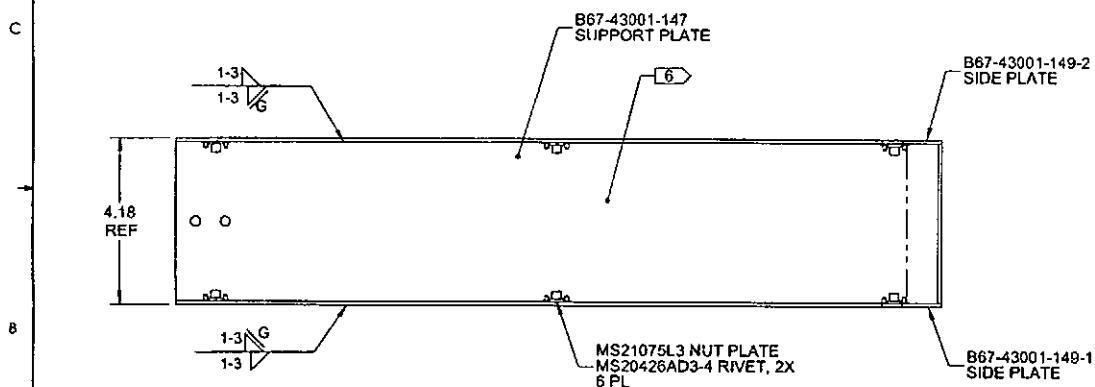
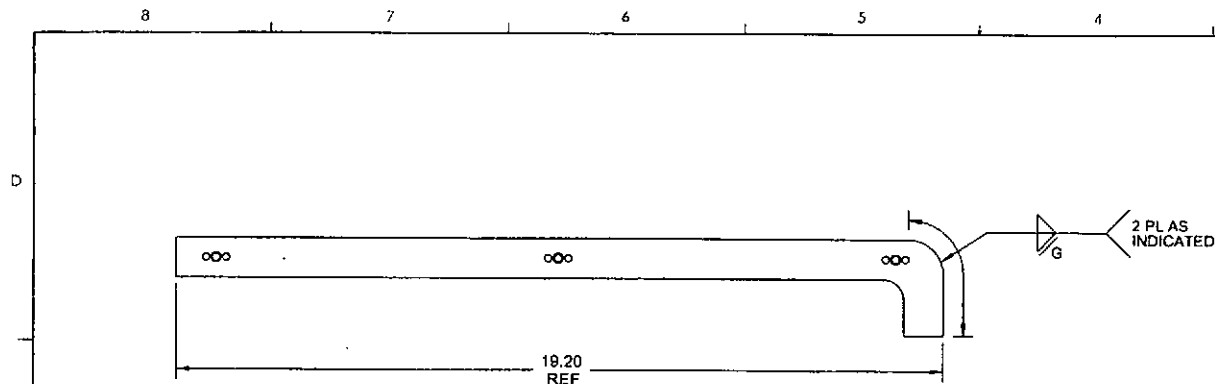
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS210751.3 Nut Plate		Purchased	No				Each	685.0000		48			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST318		5							
				123832		5							
				st507		680							
				125646		680				48			
PB67-43001-147 Support Plate		Manufactured	No				Each	12.0000		8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		12							
				52639		12				8			
PB67-43001-149 Side Plate		Manufactured	No				Each	36.0000		16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST229		36							
				99999		36				16			
MS20426AD3-4 RIVET		Purchased	No			100	Each	17,470.000	12	96			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST334		1326							
				123164		1326				96			
				ST505		8024							
				104374		12							
				123021		12							
				124814		8000							
				ST509		8120							
				124586		120							
				125578		8000							

8/13/09/06

8/13/09/03

8/13/09/03

8/13/09/6



B67-43001-67 90-DEGREE BLADE SUPPORT ASSY

ITEM	QTY -67	P/N	DESCRIPTION
1	X	B67-43001-67	90-DEGREE SUPPORT PLATE ASSY
2	1	B67-43001-147	SUPPORT PLATE
3	1	B67-43001-149-1	SIDE PLATE
4	1	B67-43001-149-2	SIDE PLATE
5	12	MS20426AD3-4	RIVET
6	6	MS21075L3	NUT PLATE

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR 09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-67 TITLE 90-DEGREE BLADE SUPPORT ASSY		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED	N/A			
DE APPR.				
DATE	10.04.28			

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-67" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) WELDING: PER QSI 004

RELEASED
R 2010-09-16
MD

#106345

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **B67-43001-67**
TITLE **90-DEGREE BLADE SUPPORT ASSY**
SCALE **NTS**
DATE **10.04.28**
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